

Date: Friday, 17/08/2007 11:21:26 AM
User: Linda Lacelle







Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE
Job Number	: 34087		
Estimate Number	: 12155		
P.O. Number	: <i>N/A</i>	Part Number	: D34791
This Issue	: 17/08/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3479 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 28571	Material	: <i>N/A</i>
Written By	: _____	Due Date	: 11/09/2007 Qty: 4 Um: Each
Checked & Approved By	: <i>[Signature]</i> 07.08.20		
Comment	: Est Rev:A New Issue 06-02-02 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S26GA	304/316 0.018 SHEET
		
	Comment: Qty.: 0.1470 f(s)/Unit Total : 0.5880 f(s) Pick: 304/316 0.018 SHEET (M304S26GA) Batch: <i>17105445</i>	
		<i>FF 07-09-06</i> 41
2.0	SHEAR	SHEAR
		
	Comment: SHEAR Cut Flat pattern 2.50" X 8.50" as per Dwg D3479	
		<i>FF 07-09-06</i> 4
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
	Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr 2-Roll part as per Dwg D3479 3-Spot weld as per Dwg D3479 and Dart QSI 018 4-Fabricate Bead using Rotary Machine as per Dwg D3479 5-Form as per dwg D3479	
		<i>MF 07-10-29</i> 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/10/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:21:26 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 34087

Part Number: D34791

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC3

VISUAL WELDING INSPECTION

MA 07/10/29



Comment: VISUAL WELDING INSPECTION

SB 07/10/29

(4)

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/10/29

(4)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: GA

mf 07-10-29

(4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/10/29

(4)

Job Completion



U 07.10.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

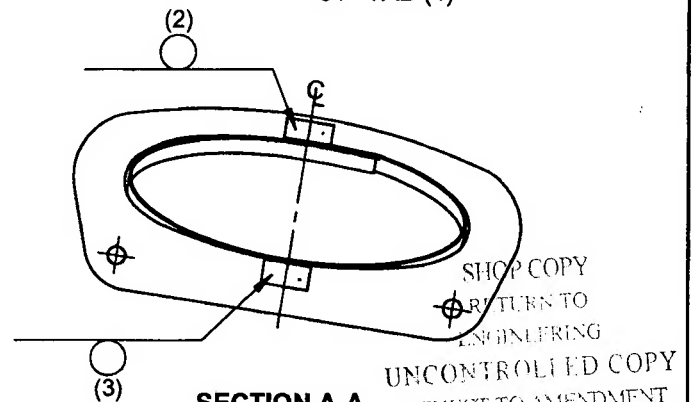
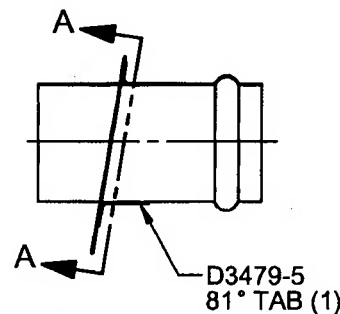
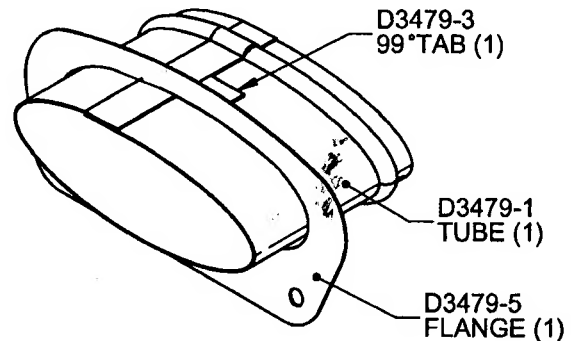
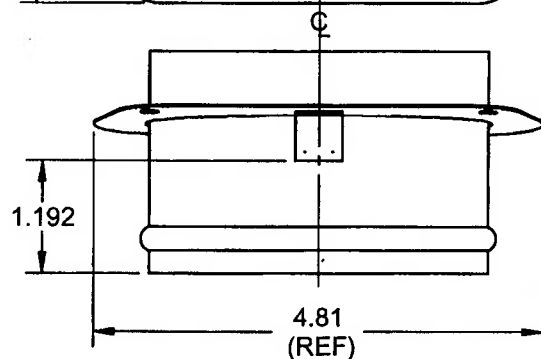
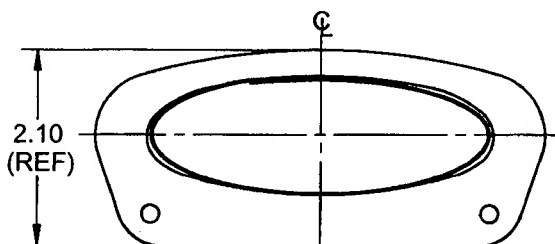
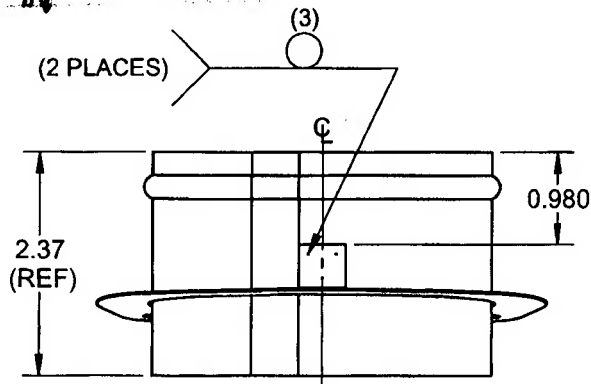
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3479	REV. A SHEET 1 OF 4
DATE 06.01.19		TITLE INLET ADAPTER	SCALE 1:2
A	06.01.19	NEW ISSUE	

06 04.03



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D3479-041 INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 018
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3479-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3479-041	INLET ADAPTER
1	D3479-1	TUBE
1	D3479-3	99 DEGREE TAB
1	D3479-5	81 DEGREE TAB
1	D3479-7	FLANGE

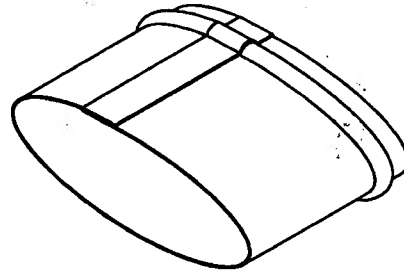
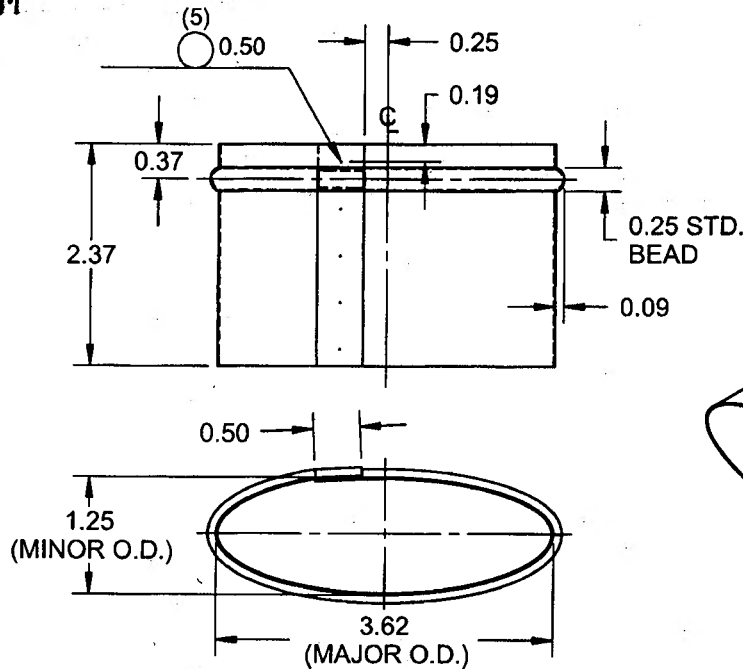
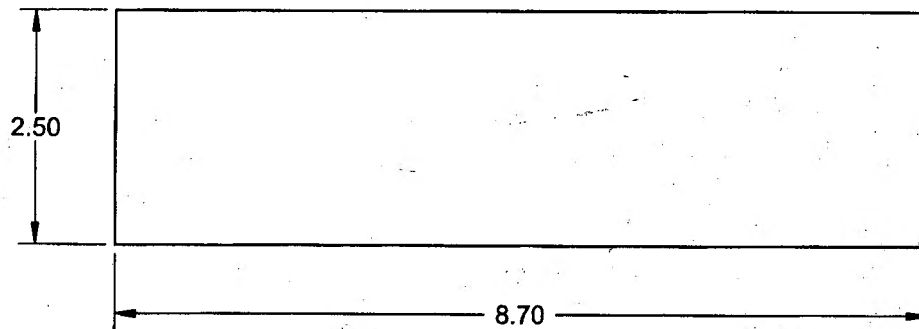
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DATE 06.01.19		TITLE INLET ADAPTER	SCALE 1:2

06.04.03

**D3479-1 TUBE****D3479-1F FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 018
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

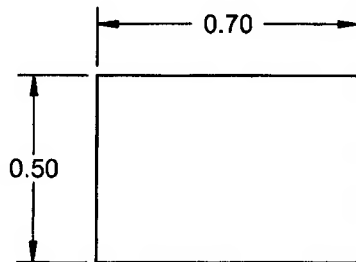
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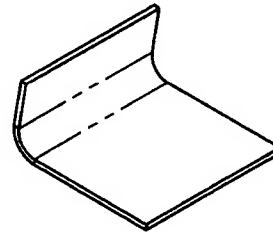
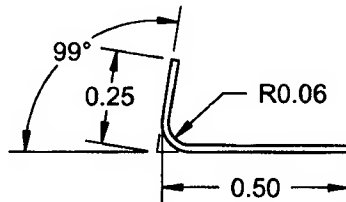
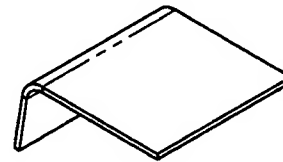
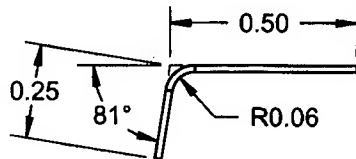
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3479	REV. A SHEET 3 OF 4
DATE 06.01.19		TITLE ADAPTER INLET	SCALE 2:1

*[Signature]* 06.04.03**D3479-3F FLAT PATTERN**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)

**D3479-3 99 DEGREE TAB**
(MAKE FROM D3479-3F FLAT PATTERN)**D3479-5 81 DEGREE TAB**
(MAKE FROM D3479-3F FLAT PATTERN)**NOTES:**

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

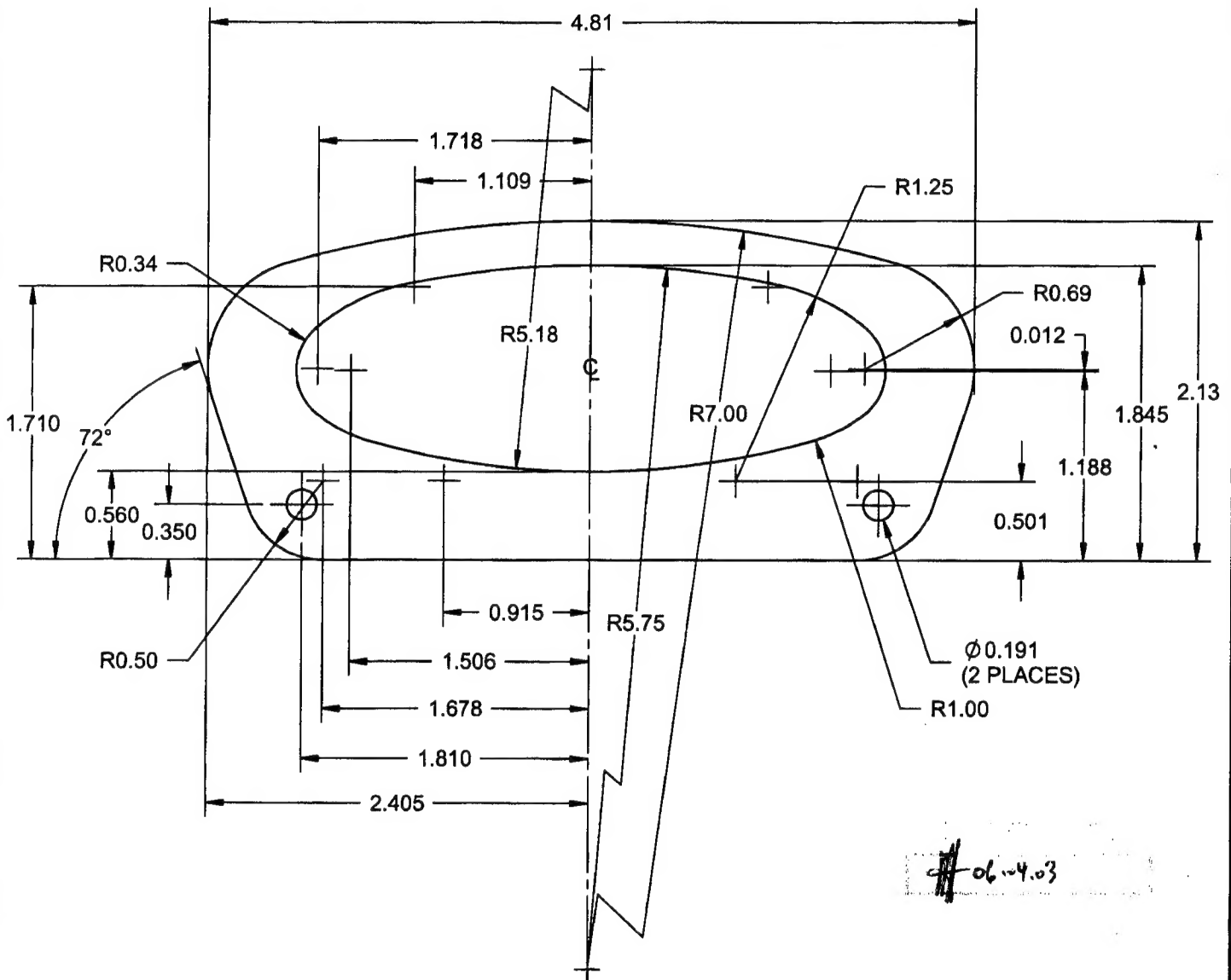
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DATE 06.01.19	TITLE ADAPTER INLET		SCALE 1:1

**D3479-7 FLANGE PLATE****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 34

EMPLOYEE: Melanie Fontaine

PART NUMBER: D 3479-1

JOB NUMBER: B 340 87

MATERIAL TYPE: 304L

MATERIAL THICKNESS: 0.08

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium SS

TEST RESULTS

	PASS	FAIL
VISUAL:	[/]	[]
PENETRATION:	[/]	[]
PULL STRENGTH:	[/]	[]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/10/29

QUALIFIER: SB